

# Work Order ID 109008

\*109008\*

Page 1

Monday, November 04, 2013 9:13:33 AM

Item ID: D4630-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Cover

Stop \*NS2\*

Start Date: 11/1/2013 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 11/8/2013 Req'd Qty: 4.00

\*4\*

Customer:

Reference: rework per ecn 13-649

Approvals: Process Plan: MUF

Date: 13-11-04

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4630

B

100

0.00

\*100\*

QC

Quality Control

Memo

0.00

PULL FROM STOCK D4630-1 X 6: - MUF 13-10-04  
2 X B92198  
4 X B98764  
AND REWORK TO NEW DRAWING REV B  
(ECN 13-649)

110

0.00

\*110\*

Mill Conv

Conventional Milling Machine

Memo

0.00

ADD 2 ADDITIONAL MOUNTING HOLES PER DRAWING REV B

13/11/12

# Work Order ID 109008

Monday, November 04, 2013 9:13:33 AM

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Page 2

Item ID: D4630-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Cover

Stop \*NS2\*

Start Date: 11/1/2013 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 11/8/2013 Req'd Qty: 4.00 \*4\*

Customer:

Reference: rework per ecn 13-649

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

Smb  
13-11-13

6

130

0.00

\*130\*

HandFinish

Memo

0.00

Hand Finishing

TOUCH UP WITH ALODINE AND PAINT WHERE NECESSARY

6x f gll is 11/13

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

Smb  
13-11-14

6

# Work Order ID 109008

Monday, November 04, 2013 9:13:33 AM

\*109008\*

Page 3

Item ID: D4630-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Cover

Stop \*NS2\*

Start Date: 11/1/2013 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 11/8/2013 Req'd Qty: 4.00 \*4\*

Customer:

Reference: rework per ecn 13-649

Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Identify as per dwg & Stock Location:

0.00

\*150\*

Packaging

Memo

57167

0.00

Packaging

13/11/14 (6)

DAS  
32  
9-89

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

13/11/18

MS  
13-11-17



# Picklist Print

Monday, November 04, 2013 9:13:32 AM

Page 1

Work Order ID: 109008

Parent Item: D4630-1

Parent Item Name: Cover

Start Date: 11/1/2013

Required Date: 11/8/2013

Start Qty: 4.00

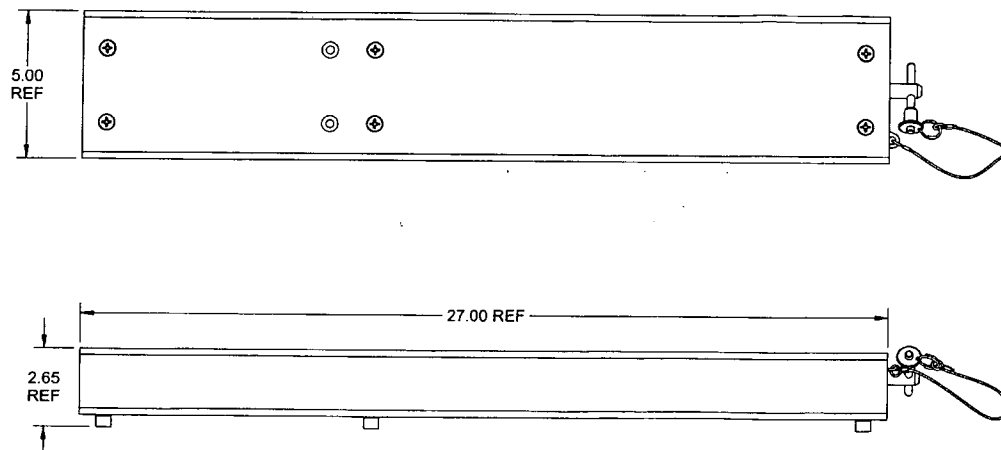
Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-06-26 JLM VERIFIED BY:DD IPP REV:B 12.10.02 PER DWG  
REVA DD VERF:JFS IPP REV:C 13.11.01 PER DWG REVB DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4630-1 Cover		Manufactured	No				Each	0.0000		6			

4 x 98764  
2 x 92198  
mf 13-11-04

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4630-041	SKIDTUBE STEP ASSEMBLY
1	1	D4630-1	COVER
2	3	D4630-3	BRACKET
3	1	D4630-5	PIN
4	1	D4630-7	PIN
5	1	D4697-041	LANYARD
6	6	MS21043-4	NUT
7	2	MS21043-6	NUT
8	2	MS27151-19	NUT
9	6	MS24694-C102	SCREW
10	1	MS17984-C415	PIN, QUICK RELEASE
11	2	MS15795-814	WASHER



**D4630-041 SKIDTUBE STEP ASSY**

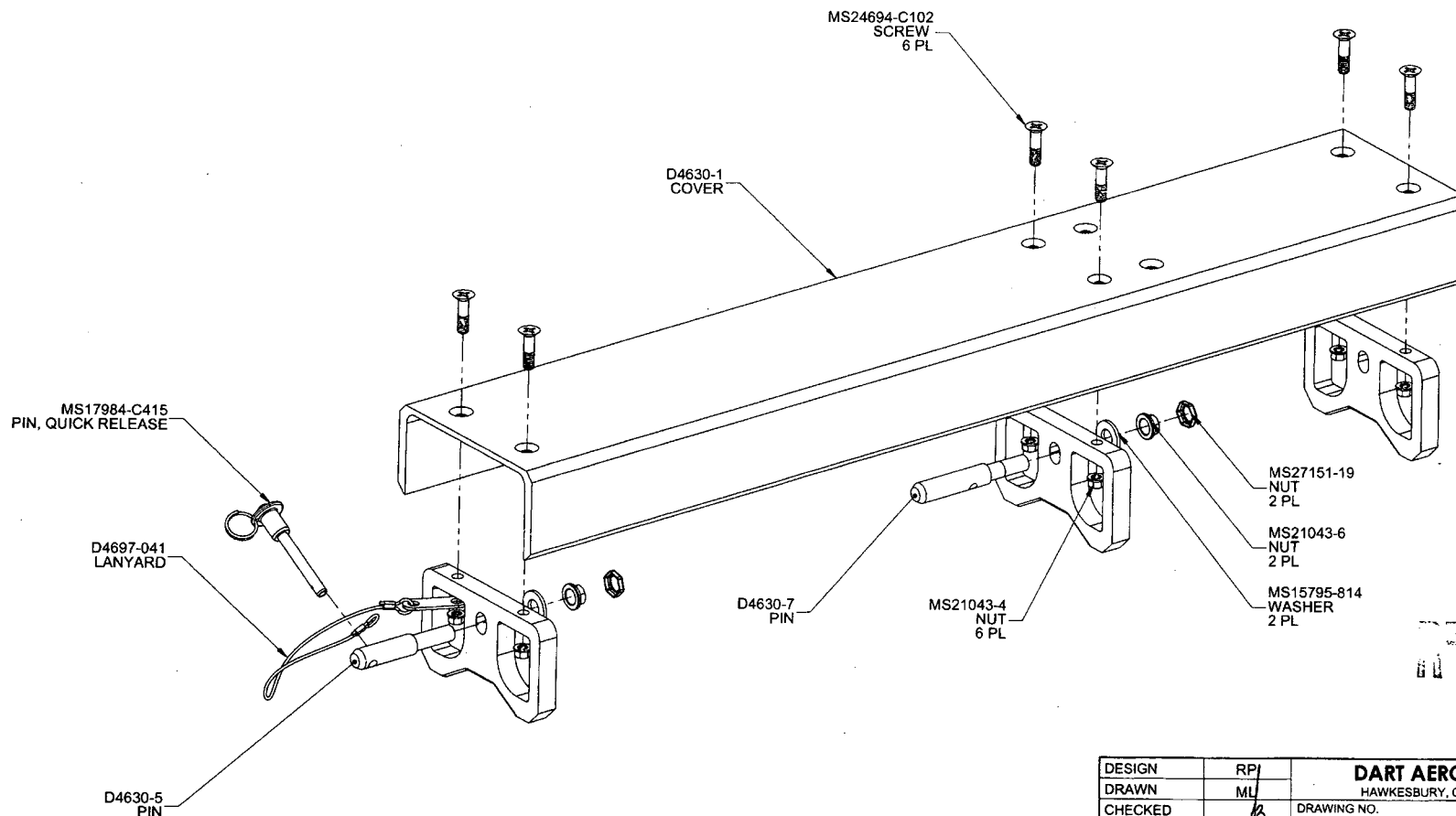
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: APPLY BLACK ANTI-SKID PAINT WHERE INDICATED PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4630-041" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 5.98 lbs

B	TWO ADDITIONAL MOUNTING HOLES ADDED TO D4630-1 COVER. (ZN C7-3)	ML	13.09.30
A	NEW ISSUE	RP	12.08.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA.	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4630	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE STEP ASSY	NTS
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8 7 6 5 4 3 2 1

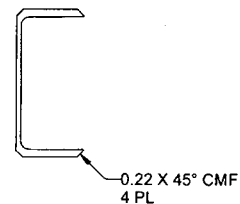
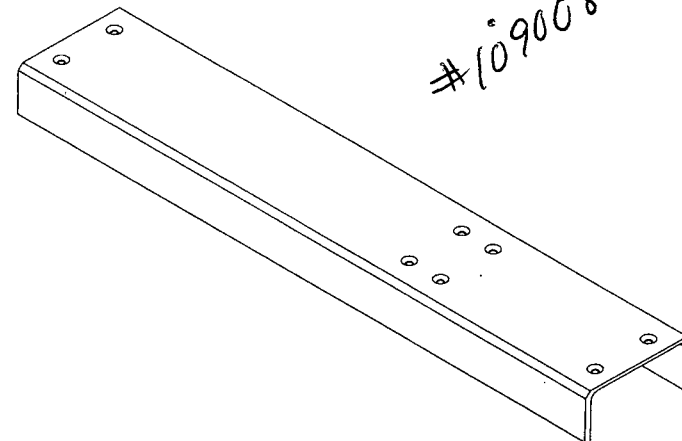
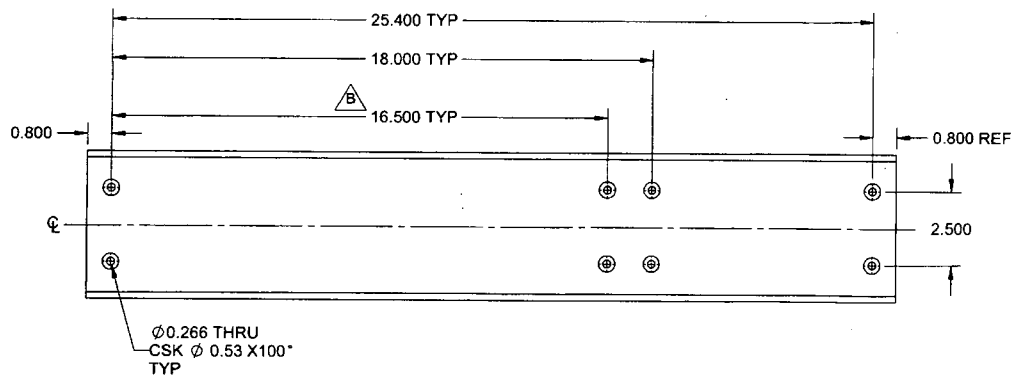
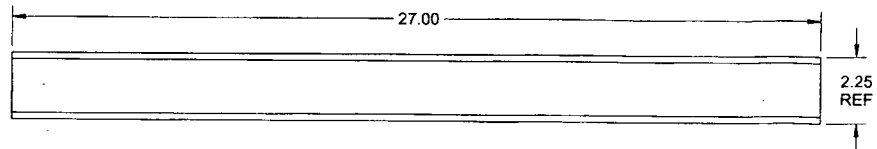
#109008



RELEASE  
2013-10-30

DESIGN	RPI	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4630	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	SKIDTUBE STEP ASSY	SCALE
DE APPR.	<i>[Signature]</i>	DATE 13.09.30	NTS
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8 7 6 5 4 3 2 1



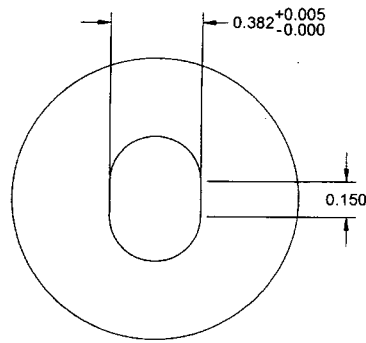
# **D4630-1 COVER**

## **NOTES:**

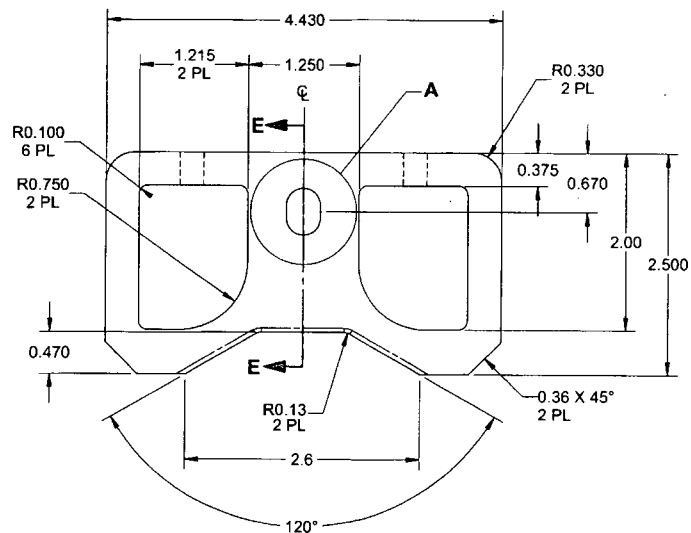
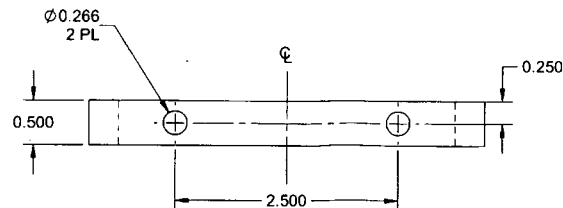
- 1) MATERIAL: MAKE FROM EXTRUSION D6209
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 4.68 lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
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CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	MB	D4630	SHEET 3 OF 6
APPROVED	MB	TITLE	SCALE
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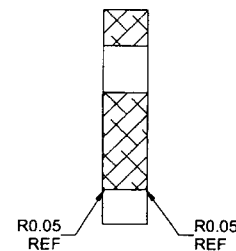
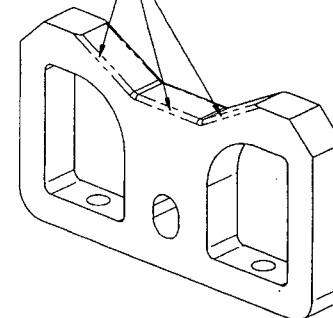


**DETAIL A**



**D4630-3 BRACKET**

BREAK SHARP EDGES  
0.05 MIN  
(BOTH SIDES)



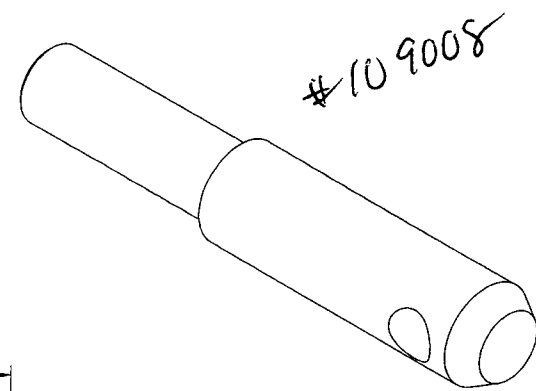
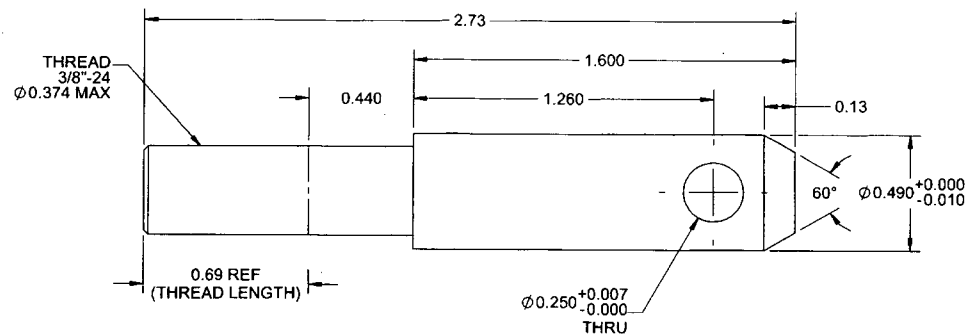
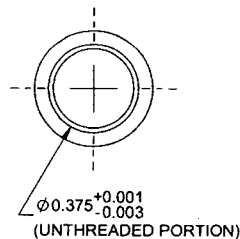
**SECTION E-E**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T68
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	<b>D4630</b>	SHEET 4 OF 6
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	<b>SKIDTUBE STEP ASSY</b>	NTS
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RELEASED  
2013-10-30



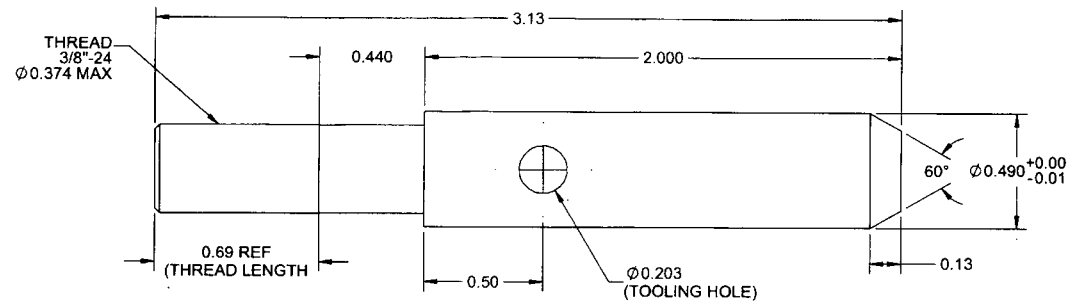
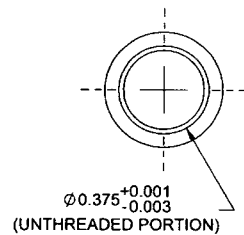
# **D4630-5 PIN**

## **NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582  
REF DART SPEC M303R1.000 OR  
AISI 304/316 SS ROUND BAR PER ASTM A276  
REF DART SPEC M304R1.000
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

RELEASED  
2013-10-30

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	MB	DRAWING NO. <b>D4630</b>	REV. B
MFG. APPR.	MB	SHEET 5 OF 6	
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	<b>SKIDTUBE STEP ASSY</b>	NTS
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**D4630-7 PIN**

**NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582  
REF DART SPEC M303R1.000 OR  
AISI 304/316 SS ROUND BAR PER ASTM A276  
REF DART SPEC M304R1.000
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

RELEASED  
2013-10-30  
JH

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JH	DRAWING NO. <b>D4630</b>	REV. B
MFG. APPR.	JH	SHEET 6 OF 6	
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	<b>SKIDTUBE STEP ASSY</b>	NTS
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